

Date: Thursday, 30/10/2008 9:18:31 AM
 User: Melanie Fauteux

Process Sheet

DUPLICATE

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SQUARE TUBE
 Job Number : 41907 - 2
 Estimate Number : 13425
 P.O. Number :
 This Issue : 30/10/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 08/09/2008 Type : LARGE FAB ASSY
 Previous Run : 41789
 Part Number : PB6743001203
 Drawing Number : B6743001 P.17
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 26/09/2008
 Qty: 30 Um: Each
 Written By :
 Checked & Approved By : MF 08-10-30
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6TS1000W120

6061T6 SQ TUBE 1.00 x 1.00 X .120w



Comment: Qty.: 1.6844 f(s)/Unit Total: 15.1597 f(s)

6061T6 SQ TUBE 1.00 X 0.065 - .120" *Handwritten: THIS W/O ONLY 1008.11.03*
 batch: *M109928*

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- cut to length as per dwg
- 2- make a 0.050" chamfer on both ends of tube
- 3- deburr

DTP 08/11/13

(21)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

center
S 08/11/13
 (21)

4.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

- 1- drill holes as per dwg
- 2- make a 0.050" chamfer (100 degree) on both side of the 2 holes
- 3- deburr

DTP 08/11/13

(21)

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

center
S 08/11/13
 (21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 30/10/2008 9:18:31 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 41907

Part Number: PB6743001203

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001227

Bushing



Cpl 08-11-25



Comment: Qty.: 2.0000 Each(s)/Unit Total: 18.0000 Each(s)

Bushing

batch:

~~41916~~ ✓

~~B400273~~ ✓

B 43712 → 18 ✓

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(X9)

Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

Cpl 08-11-25

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(X9)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

Cpl 08-11-25

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/11/26

(9)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/11/26 (X9)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *438*

8/11/26

SP

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26

Job Completion



MF 08-11-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
#00 01 20

REPLACED BY
SUPERCEDED BY
D-440-15

D

C

B

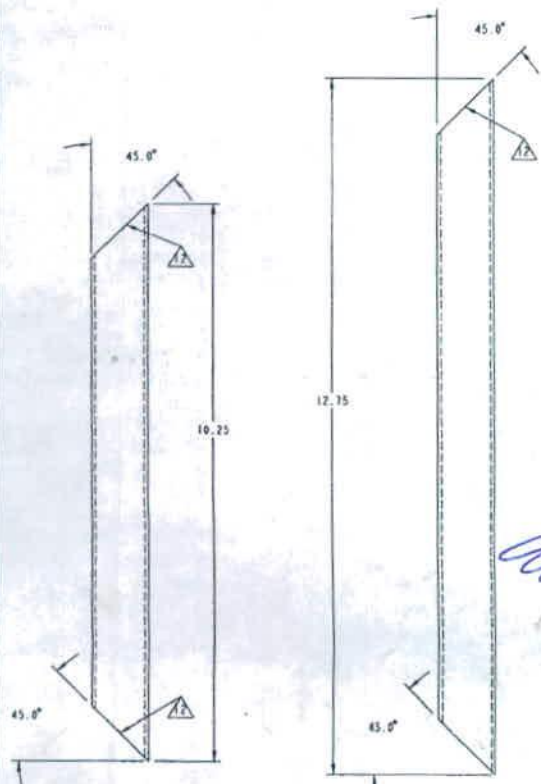
A

D

C

B

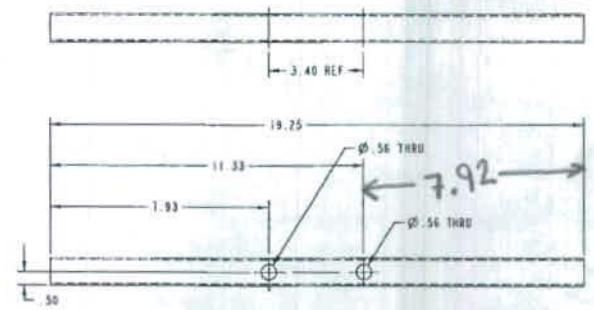
A



-209 SQUARE TUBE
MATERIAL: 1.00 SQ X .065 WALL, 6061-T6
QD-A-200/B
SCALE: 1.000
②

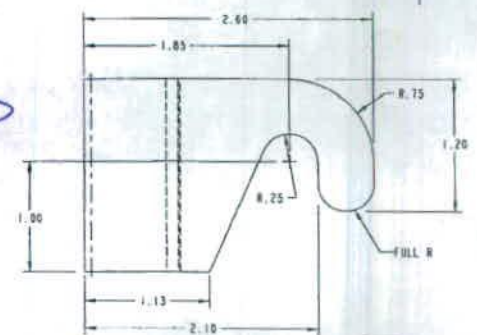
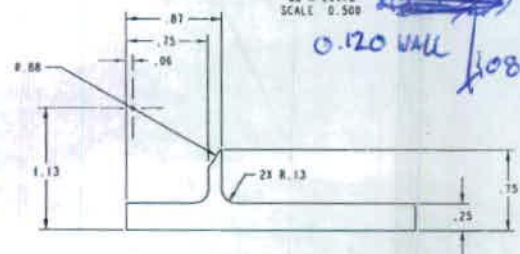
-211 SQUARE TUBE
MATERIAL: 1.00 SQ X .065 WALL, 6061-T6
QD-A-200/B
SCALE: 1.000
①②

Udo 41907

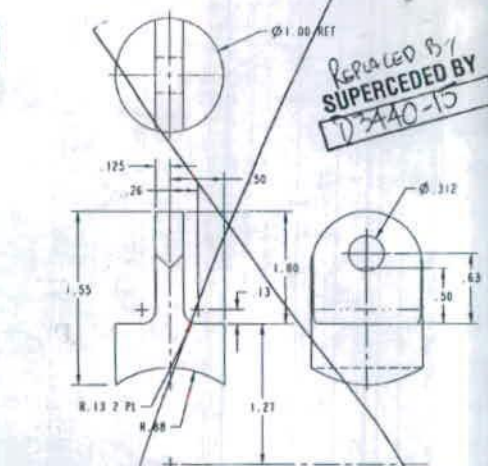


② -203 SQUARE TUBE
MATERIAL: 1.00 SQ X .065 WALL, 6061-T6
QD-A-200/B
SCALE: 0.500

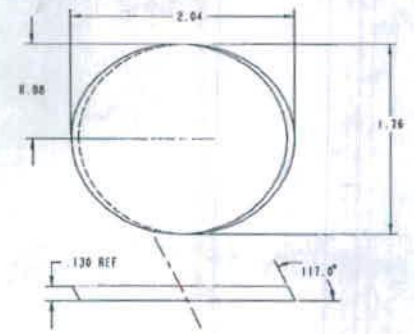
0.120 WALL 108.11.03



② -213 FLANGED HOOK
MATERIAL: 6061-T6 QD-A-200/B
SCALE: 2.000
2M



① -215 CONTOURED MALE EYE
MATERIAL: 1.00 RND, 6061-T6
QD-A-200/B
SCALE: 2.000
JLM



-199 OUTER TUBE END CAP
MATERIAL: .125 THK, 6061-T6
QD-A-250/11
SCALE: 2.000
②

PREMIER AVIATION, INC.
1000 Aviation Parkway, Grand Prairie, Texas 75050
JLOSUV8 B67-43001 11 of 45

ORIGINAL

100

100

100

100

100